

Sunday, 12/4/2005 12:41:44 PM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number	: 25084A		
Estimate Number	: 10163		
P.O. Number	: N/A	Part Number	: D206642241
This Issue	: 12/4/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2650 REV D1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25003A	Drawing Revision	: D1E
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/10/2005
Checked & Approved By	: <u>SEE ABOVE USER &amp; DATE</u>	Qty:	1 Um: Each
Comment	: Est Rev:M 04.12.02 Revised procedural steps KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B24497 DP05-12-15 1

2.0	D32861	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B24206 BE 06-01-03 ①

3.0	D2647	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B20535 BE 05-12-19 ①

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

DP05-12-15 ①

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

DP05-12-15 ①

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Description :

Qty Part Number Description Batch

A/R Aluminum Rod M15855/M18901 BE 05-12-19 ①

4-Grind weld flush to cap on top surface only. BE 05-12-19 ①

5-Cut Aft end as per dwg 2650 from front of tube and Deburr DP 05-12-22 ①

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 BE 06-01-03 ①

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. BE 06-01-03 ①

8-Locate DT8732 from inner Aft saddle hole &amp; 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 &amp; D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 &amp; doubler leaving DT8732 for added support. BE 06-01-03 ①

9- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. BE 06-01-03 ①

10-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. BE 06-01-03 ①

11-Remove and Deburr D3286-1 doubler. BE 06-01-03 ①

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 BE 06-01-03 ①

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder. BE 06-01-03 ①

14-Remove indexing edge using DT8741 as per Dwg D2650 BE 06-01-17 ①

15-C'sink GHW rivet holes as per Dwg D2650 BE 06-01-17 ①

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650 BE 06-01-19 ①

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. BE 06-01-19 ①

3-Deburr tube and blow out chips from inside the tube BE 06-01-19 ①

NOTE: INFORMATIONALLY ASSIGNED TO PROVIDER FOR RECORD ONLY

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Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*a.m 06-01-19* *(1)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06-01-19*

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

*BE 06-01-19* *(1)*

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

*BE 06-01-19* *(1)*

3-Deburr and blow out all chips from inside the tube

*BE 06-01-19* *(1)*

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*06-01-20*

11.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

*18491* *Pm 06-01-23*

*(52)*

12.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3

Web

*B24498*

*Pm 06-01-24* *(1)*

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

*Pm 06-01-23* *(1)*

Form: rprocess

H.I.FORMS Quality Assurance

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-01-24 Time: 10:30

Finish Date: 06-01-26 Time: 7:30

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M19597

Sikaflex expire date: 06-06-20

*pmc 06-01-24 (1)*

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*7-06-01-26*

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649 Crossbolt spacer *B24200 BE 06-01-30*

*(18)*

16.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer *B23932 BE 06-02-03 (1)*

0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *M15855 BE 06-01-30 (1)*

2-Grind welds flush as per Dwg D2650. *BE 06-01-31 (1)*

3-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr *pmc 06-02-06 (1)*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each

Form: rprocess

H:\FORMS\Quality Assurance\approved\CAINCRWO RevD

W/O:		WORK ORDER CHANGES								
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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

BE 06-02-03(1)

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m 4548 Pm 06-02-07

(2)

19.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

m 7808

Pm 06-02-07

(2)

20.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

B2103

Pm 06-02-07

(1)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pm 06-02-07

(1)

22.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using a. m 06-03-15 paint screw, and mask GHW studs.

(1)

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/03/15

(1)

25.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad 324843

(5)

26.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe B 25329

(1)

27.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe B 20532

(1)

28.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe B 20756

(1)

29.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad B 24417

a.m. 06-03-15

(1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 25084A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130

Inserts

M18293

or (see QSI 017)

44

31.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

19185

44

32.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

M16941

44

33.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs

B25010

18

34.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-3

O-Rings

B23491

18

a.m 06-0

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M 6874

1

36.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer M 16060

1

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M 19597

a-m 06-03-15

Sikaflex expire date:

06-18-06

1

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650.

Clean excess adhesive.

a-m 06-03-15

3-Install MS27039-4-06 Screw as per DEO 9153.

a-m 06-03-15

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

M

06 03 15

1

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap 3 22587

a-m 06-03-15

1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/23  
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Description :

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M76 941

2

a.m 06-03-15

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M19145

2

a.m 06-03-15

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M19597

Sikaflex expire date: 06-18-06

a.m 06-03-15

1

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: 100037

a.m 06-03-15

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

06/03/17

M 06 03 17

1

44.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10P

06/03/23

Job Completion



u 06-03-23

W/O:		WORK ORDER CHANGES						
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